

Date: Friday, 22/05/2009 4:46:08 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 48166	
Estimate Number : 12794	
P.O. Number :	Part Number : D356613
This Issue : 22/05/2009 S.O. No. :	Drawing Number : D3566 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 47435	Material :
Written By :	Due Date : 29/05/2009 Qty: 12 Um: Each
Checked & Approved By : <u>20 09 05 25</u>	
Comment : Est Rev:A New Issue 07-03-08 ec Est Rev:B Added Drain Holes 07-07-09 JLM Est Rev:C As per Rev C 07-09-09 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MNEO60S063	NEOPRENE SHEET 0.063



Comment: Qty.: 0.2409 sf(s)/Unit Total : 2.8914 sf(s)

NEOPRENE SHEET 0.063

111469 139-6-8

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3566

Dwg Rev: CProg Rev: C

139-6-8

(23)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

Sort 66/08 counter 123

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: FP12

9666

(23X)

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:46:08 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 48166

Part Number: D356613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/09 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 481660
Description: Gasket		Part Number: D3566-13
Inspection Dwg: D3566	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.00	+/-0.030	7.003	✓			
3.50	+/-0.030	3.509	✓			
2.43	+/-0.030	2.427	✓			
3.10	+/-0.030	3.104	✓			
0.30	+/-0.030	.303	✓			
0.30	+/-0.030	.302	✓			
0.063	+/-0.010	.067	✓			
Ø0.188	+0.005/-0.001	.190	✓			

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 9-6-8	Date: 09/06/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.20	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	08.09.04	Dwg Rev updated	KJ/DD	

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RETURN TO
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SUBJECT TO APPROVAL
WITHIN 30 DAYS
WORK CANCELLED
NO.

8

7

6

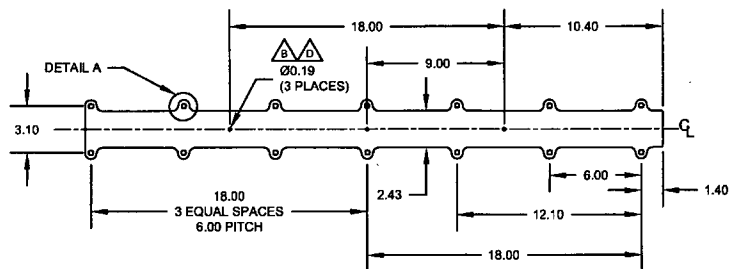
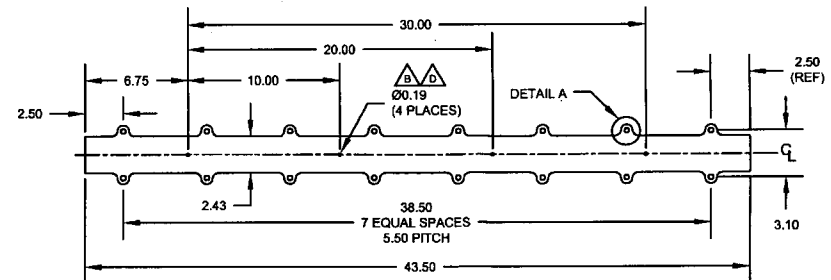
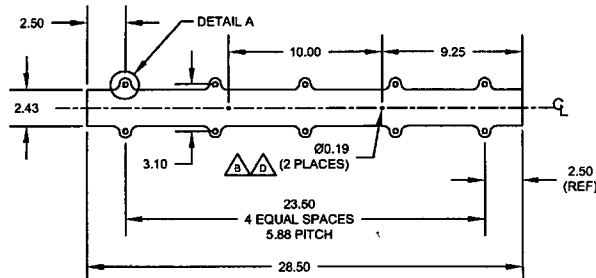
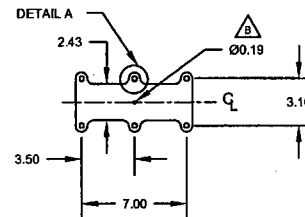
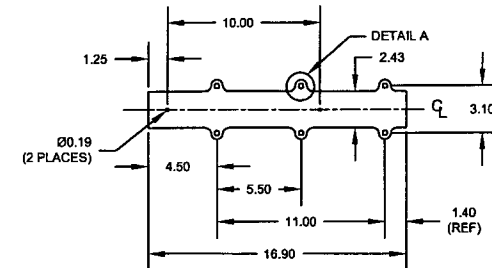
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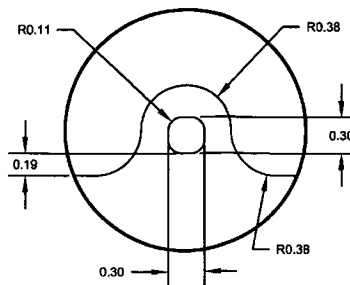
3

2

1

**D3566-1 GASKET****D3566-5 GASKET****D3566-7 GASKET****D3566-13 GASKET****D3566-15 GASKET****RELEASED**

07.08.04

**DETAIL A**
SCALE 1:1

WEIGHTS:	
D3566-1	0.29 lbs
D3566-5	0.36 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

NO. 12160
WORK CENTER
SUBJECT TO CHANGE
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SHOP COPY

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) PARTS ARE SYMMETRIC ABOUT CL

C	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;		CB	07.08.21
	ADD DRAIN HOLES		PH	07.04.17
B	NEW ISSUE		PH	06.12.18
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CB			
CHECKED	PH	DRAWING NO.	REV. C	
MFG. APPR.	PH	D3566	SHEET 1 OF 1	
APPROVED	PH	TITLE	SCALE	
DE APPR.	PH	GASKET	1:8	
DATE	07.08.21		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	